Work Order ID 72769

Friday, August 12, 2011 2:34:38 PM

Item ID: D3874-2 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Floor Protector

Start Date: 8/12/2011 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 8/19/2011 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** [illegible] **Date:** 11-08-12 **Tooling:** **Date:** **Run Start** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D3874 / A									
100		0.00				x4			WL 11/08/17
HandThermo	**Memo**	0.00							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								
105		0.00				x4			WL 11/08/17
HandThermo	Dry Material								
Hand Finishing Thermoforming	**Memo** Dry Sheet as per QSI022 POLYCARBONATE	0.00							

Temp: 240° F

Time IN: 4:00 pm 11/08/16

Time OUT: 7:00 am 11/08/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 72769

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QC: ___ **Date:** ___ **SPC (Y/N):** ___ **Date:** ___ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00				x4 DL			DL 11/08/17
Thermoform	**Memo**	0.00							
Thermoforming Machine	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA039 using tool DT9474 Dwg Rev: A Folio Rev: B								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				x4 DL			DL 11/08/17
QC	**Memo**	0.00							
Quality Control	Visuallly inspect part for proper formation and texture								
130	QC8- Inspect parts - second check	0.00				+4 2			
QC	**Memo**	0.00							
Quality Control									

S 11/08/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 72769

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Approvals: **Process Plan:** ___ **Date:** ___ **Tooling:** ___ **Date:** ___ **Run Start**

QC: ___ **Date:** ___ **SPC (Y/N):** ___ **Date:** ___ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
HandThermo	**Memo**	0.00				x 4			DL 11/08/18
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				x 4			DL 11/08/18
Quality Control	Complete FAI document								
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00				x 2			8 11/08/18
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
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NOTE: Date & initial all entries

Work Order ID 72769

Friday, August 12, 2011 2:34:38 PM

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Item Name: Floor Protector

Start Date: 8/12/2011 **Start Qty:** 4.00 **Cust Item ID:**

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location:_____	0.00				11/8/PLS			
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

11/8/22

11-08-22 (H)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Friday, August 12, 2011 2:34:43 PM

Work Order ID: 72769

Parent Item: D3874-2

Parent Item Name: Floor Protector

Start Date: 8/12/2011 **Required Date:** 8/19/2011

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev. A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL
IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	1,938.942	4.38	17.52			
Lexan Sheet													

Location	Loc Qty	Loc Code
therm	1938.942621	
113127	1938.94262	

DL 11/08/17

17.52 sq ft.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	72769
Description: Floor Protector	Part Number:	D3874-2
Inspection Dwg: D3874 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	N/A			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

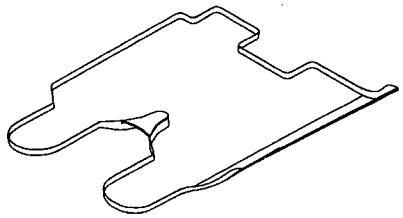
Measured by:	DL	Date:	11/08/17

TRIMMING SECTION

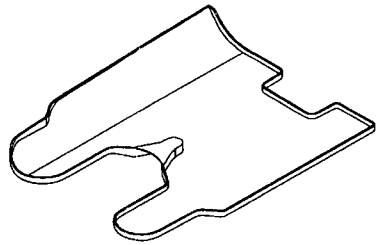
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.091"	✓			
0.065	Min	0.104"	✓			
0.5	Min	0.55"	✓			
21.9	REF	21.875"	✓			

Measured by:	DL	Date:	11/08/18
Audited by:	S	Date:	11/08/18
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	



D3874-1 FLOOR PROTECTOR



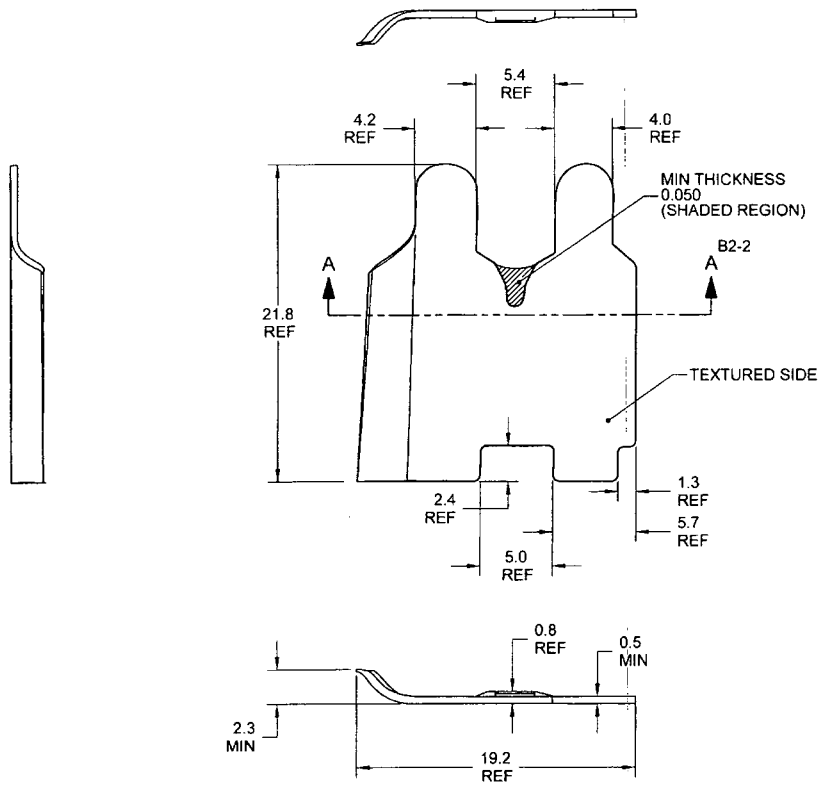
D3874-2 FLOOR PROTECTOR

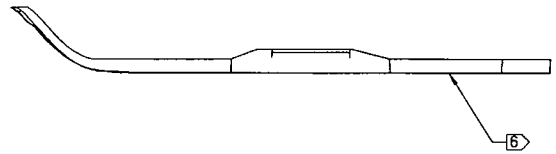
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77769 11-08-12

RELEASED
31/08/05 NM

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	PH	09.01.29

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	PH	
CHECKED		DRAWING NO. D3874 REV. A
MFG. APPR.		SHEET 1 OF 3
APPROVED		TITLE FLOOR PROTECTOR SCALE NTS
DE APPR.		
DATE	09.01.29	





C5-2

SECTION A-A
SCALE 2X

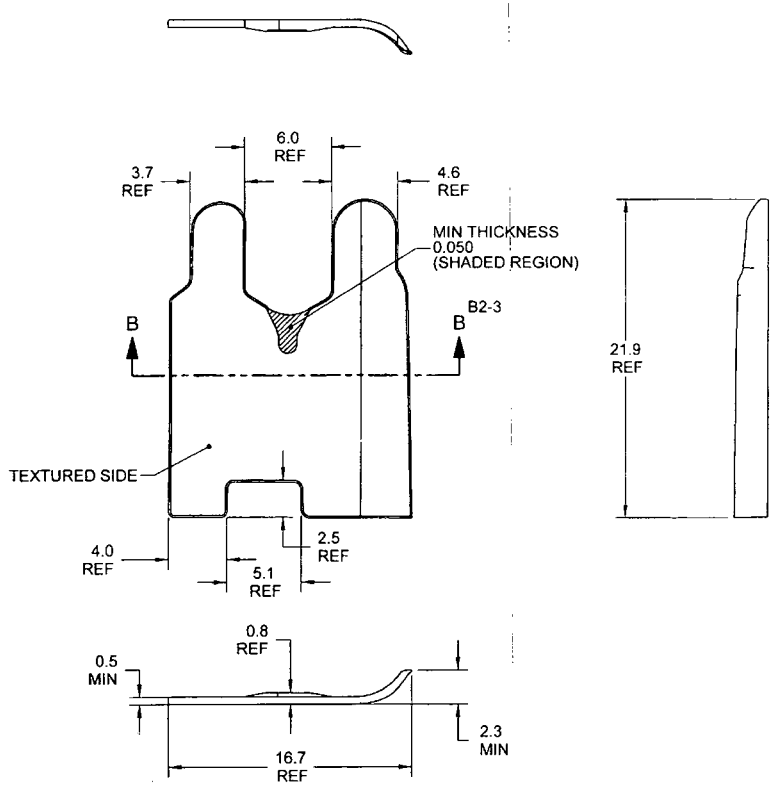
D3874-1 FLOOR PROTECTOR

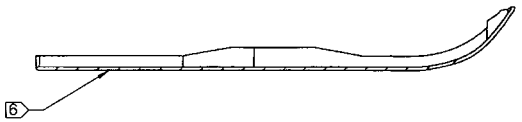
7269

RELEASED
6/05/09

NOTES:
1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR
(MLEXS.118-90318-08)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
7) WEIGHT: 1.5 lbs
8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022--TRIM PER MOLD
9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

DESIGN	PW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	PW	
CHECKED		DRAWING NO. D3874 REV. A SHEET 2 OF 3
MFG. APPR.		
APPROVED		TITLE FLOOR PROTECTOR SCALE NTS
DE APPR.		
DATE 09.01.29		





C5-3

SECTION B-B
SCALE 2X

12769

D3874-2 FLOOR PROTECTOR

RELEASED
09/05/09

NOTES:
1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR
(MLEXS.118-90318-08)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
7) WEIGHT: 1.5 lbs
8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3874 REV. A
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE FLOOR PROTECTOR SCALE NTS
DE APPR.		
DATE 09.01.29		